0.00

Memo

- QC

Quality Control

											DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP		QA Closed:	Date:	•
						DISPOSITION			·	AGAINST DE			· · · · · · · · · · · · · · · · · · ·
Work Order:							_		 1		AITTIVIEITI		
Part No						Rework Scrap Use-as-is					Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR I	No.					Work Order Update]	1110111	Large Fab	Composite	1100/3101	Supplier	
Root					Descri	ption of work order update	1	Initial	Ac	tion	Sign &		,
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ц					•							
Equip/Tooling	Ш												
Operator	Ш]										
Material	Н						}						
Setup	Н		· ·										
Other	Н			ŀ								·	
Process	Н		<u> </u>										
Supplier	Н						ŀ						
Training	Н		ļ]			ł						
Unapproved				<u> </u>	1	. F	AUI	T CATE	I GORY	·	l	I	I
Landi	ing G	iear				General		·· VAIL					· · · · · · · · · · · · · · · · · · ·
Landing Gear Bending						Bend		Grain			Ovalized		Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Broken/Damaged

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

00

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Work Ordo)29		*950)29*					Page	2
Item ID: Revision ID: Item Name:	D3916-041 Rib Assembly			Accept	*N900040100		100)* s	etup Star Stop	14.21	
Start Date: Required Date: Reference:	1/21/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:				. =	
Approvals:		n:	Date:	Tooling: SPC (Y/N):		Date:		R	tun Star Stop	"NRT"	
Sequence ID/ Work Center II 107 *107* Large Fab Large Fab	D	Memo	rod Batch: MV35833 ing as per dwg D3916 is flush	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp	-
*110 *110* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00	13.4.20	0AS 24 25		6		. <u> </u>	

120

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00 Memo

									DQA:	Date:		
NCR: Y	res / No				WORK ORDER NON-O	CONFOR	MANCE / UPD		QA Closed:	Date:		
					DISPOSITION			AGAINST DE				
Work Orde	er:		–		_	,						
	No				Rework Scrap Use-as-is	Ther	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	lo				Work Order Update]	Large Fab	Composite		Supplier		
Root				Descri	ption of work order update	Initial	Acti	ion	Sign &	•		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descri	iption	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling					·							
Operator												
Material												
Setup			1				76.	•				
Other		ļ										
Process		ļ										
Supplier		ŀ										
Training		ŀ										
Unapproved			<u></u>				<u> </u>					
			 			AULT CATE	GORY					
Landir	ng Gear				General	п. .		[1		.	
	Bending				Bend	Grain		-	Ovalized	<u> </u>	Pressure/Forced	
	Centre Not Concentric to O/S Cracks Crushed/Crimped.				BOM/Route	Hardw			Over/Under	 	Temperature/Cure	
ļ					Broken/Damaged	—	ion Incomplete	<u> </u>	Part Incorre	· ·	Weld	
					Burrs	\blacksquare	tions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			<u> </u>	Contamination		enance	<u> </u>	Part Moved			
	Heat Tre			·	Countersink	Mislab			Positioned V	_	7	
		n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other	
	Ripples in				Drill Holes	Offset						
	Torque V	Vaves in 8	Extrusio	n	Drawing	Out of	Calibration					

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Orde				*950	29*					Page 3
Item ID: Revision ID:	D3916-041			Accept	*N9000	40100)* 5	Setup Star	1 71	S1*
Item Name: Start Date: Required Date: Reference:	Rib Assembly 1/21/13 1/21/13	Start Qty: 2.00 Req'd Qty: 2.00	*?* * ? * (6	Cust Item ID: Customer:				IV.	S2*
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):	Date:		I	Run Sta Sto		R1* R2*
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Stock	C Location: WA 4	Set Up/ Run Hours		Fool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging		Memo		0.00	13.4.22		6			
140		QC21- Final Inspection - W	ork Order Release	0.00				12/1	120	2
*14 0 *		Memo		0.00				1-/19	1-7	

Quality Control

13/4/23 dd

NCR:	Yes	/	No

NCR: Y	·																	
												QA Closed:	Date:					
Nork Orde	r:						DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part N	Part No. Scrap Use-as-is NCR No. Work Order Update								ر Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root Description of work order u									Initial Action Sign &									
Cause		Date	Step	Qty	<i>Des</i>		or Non-conformance	1	1				Verification	QC Inspector				
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining																		
Landin	a Gos	· r					General	AUL	T CATE	JUKY			· · · · · · · · · · · · · · · · · · ·					
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				-	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/U nance led ialibration	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	et ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other					
	Turning Sequence						Finish		Out of S	equence								

Outside Dimensions

DQA:

Date:

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Wave/Twist in Tube

Folio

Picklist Print

January-02-13 12:48:01 PM

Work Order ID:

95029

Parent Item:

D3916-041

Parent Item Name:

Rib Assembly

Comments:

IPP RevA: New issue DD verified by:EC verified by:EC

Start Date: 1/21/13

Required Date: 1/21/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

	verified by:EC													-
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D3759-1 Bushing	10 19 2 - 100	Manufactured	No			100	Each	244.0000	7	44(0	(<u>(</u>	13-04	-15	?D
-				Location		Loc Qty	<u>L</u>	oc Code						
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				6648	9	1								
				7921	3	1								
				8346	4	7								
				8655		20								
				8978		11						*		
				9078	69	204					21	3118		
M304TS0.750W.049 304 SQ Tube .75x.75x.049	9W	Purchased	No			100	f	829.6048	4.166 S/A	* 8.770526 2)	3/3-0	.511 0 <u>7-</u> 26		pties
	•			Location		Loc Oty	Lo	oc Code						
				MAT017		2.0156214								
				1218	98	2.0156214								
				WA006		827.5891859								
				1222	201	0.1626				· ·				
				1224	25	39.0000000								
				1226	666	0.7293								
				1227	10	20.5								
				1232 1234		264.5 502.697286	n	1.1244	192 2	5.3118				

IPP Rev:B as per dwg revA 10.03.15

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE Work Order: Part No. NCR No. DISPOSITION Rework Skid-tube Crosstube Part No. Water Jet Engineering Quality Rec/Store/Packaging Other Supplier Work Order Update Date Stép Qty Description of work order update Initial Action Sign & Verification QC Inspector Doc/Data Cause Date Stép Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector Material General General General General General General General General Work Order Update Disposition Crosstube Crosstube Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier Crosstube Rec/Store/Packaging Other Supplier Crosstube Swidt-tube Crosstube Rec/Store/Packaging Other Supplier Crosstube Crosstube Rec/Store/Packaging Other Crosstube Rec/Store/Packaging Other Crosstube Crosstube Rec/Store/Packaging Other Crosstube Crosstube Rec/Store/Packaging Other Crosstube Crosstube Rec/Store/Packaging Other Crosstube Rec/Store/Packaging Other Crosstube Crosstube Rec/Store/Packaging Other Crosstube Rec/Store/Packaging Other Crosstube Rec/Store/Packaging Other Crosstube Rec/Store/Packaging Crosstube Rec/Store/Packaging Crosstube Rec/Store/Packaging Crosstube Rec/Store/Packaging Crosstube Rec/Store/Packaging Crosstube Crosstube Rec/Store/Packaging Crosstube Crosstube Crosstube Rec/Store/Packaging Crosstube Cros										DQA:	Date:	
Work Order: Part No. Part No. Rework Scrap Use-as-is Work Order Update Or Non-conformance Operator Material Setup Operator Material Setup Other Oth	NCR: Y	es / No				WORK ORDER NON-C	CONFOR	MANCE / UPDA	ATE			
Rework Order Part No. Scrap Use-as-is Work Order Update Use-as-is Use								:-		QA Closed:	Date:	
Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality		DISPOSITION AGAINST DEPARTMENT/PROCESS										
Part No. Scrap Use-as-is Use-as-is	work Orde	er:				Downer!	, 	Chief tube	Crosstuba		Water let	Engineering
NCR No.	Dart N	io.								Pro		• —
Root Cause Date Stép Qty Description of work order update Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator Other Description Setup	raiti	···.				1 ' -	4 1	- 	}		· ·	, ⊢ ,
Root Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator Material Setup Other Indicated Description Date Description Date Description Date Description Other Indicated Description Other I	NCR No.					l —	''''	~ 	~	1100,010		
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling G Operator Material Setup G Other							' 	0				
Doc/Data Capip/Tooling C	Root				Descri	ption of work order update	Initial	Action	n	Sign &		
Equip/Tooling	Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descript	tion	Date	Verification	QC Inspector
Operator Image: Company of the company of	Doc/Data			,								
Material Setup Other Drocess Supplier I Supp	Equip/Tooling										ļ	
Setup	Operator											
Other Process Supplier Unapproved Telephone FAULT CATEGORY	- t		İ									
Process Supplier Training Unapproved FAULT CATEGORY	· · · · · · · · · · · · · · · · · · ·											
Supplier Training Unapproved Training Training Unapproved Training	Other											
Training Unapproved FAULT CATEGORY	}							•				
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	Unapproved	<u>. </u>	L			<u>_</u>	<u> </u>				<u> </u>	
Landing Gear General					· · · · · · · · · · · · · · · · · · ·		AULI CATE	GORY				
Bending Bend Grain Ovalized Pressure/Forced	Landir [7			<u> </u>	المعانية ا]]
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Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld			ot Concei	ntric to	U/S -	4			<u> </u>	1	 	-
			Cuimanad		-	-	_		close	4	<u> </u>	4
Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved	}		crimpea.		-			,	Cleal	1	_	J WY ON & STOCK Fulled

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

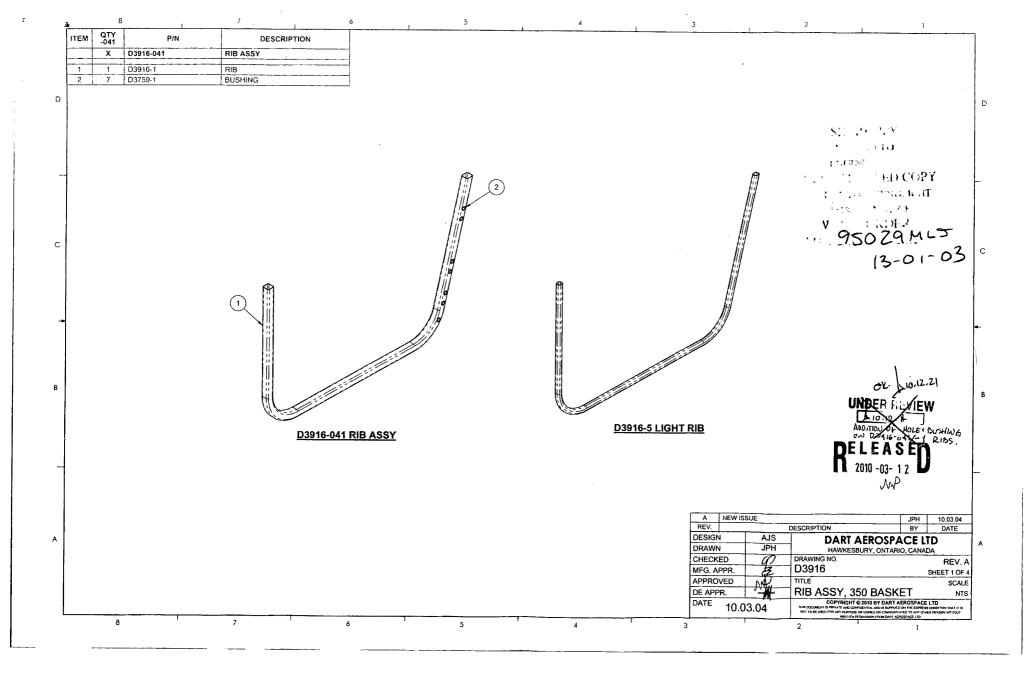
Drill Holes

Drawing

Finish

Folio

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95029 D D -- D3916-1 RIB С D3759-1 BUSHING 7 PL **D3916-041 RIB ASSY** NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT -041: 1.84 lbs
8) WELD PER DART QSI 004 DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH CHECKED DRAWING NO. REV. A D3916 MFG, APPR. SHEET 2 OF 4 APPROVED TITLE SCALE RIB ASSY, 350 BASKET

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